



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4275-1

Job Sheet 180387



Part No: D4275-1

Job Qty: 1 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Job Created: 7/5/18

Due Date: 7/17/18

Type: SOLD

Status: Scheduled

Priority: Medium

Job Tracking No: GLOSS BLACK

Created By: Linda Lacelle

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV:A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/12/18	7/12/18	0.00	0.00	Start Up Machining-2		DAS 18/07/13
100	Bandsaw	1 pcs	7/12/18	7/12/18	0.00	0.10	Bandsaw1		52 18/07/13
110	CNC Vertical Machining	1 pcs	7/12/18	7/12/18	0.71	1.85	HAAS1-4		9-89 18/07/13
120	QC	1 pcs	7/12/18	7/12/18	0.00	0.00	QC2 Machining-2		18/07/13
130	QC	1 pcs	7/12/18	7/12/18	0.00	0.00	QC8 Machining-2		18-07-16
140	HandFinish	1 pcs	7/12/18	7/12/18	0.00	0.15	HandFinish1		18-07-16
145	Powdercoat	1 pcs	7/12/18	7/12/18	0.00	0.13	Powdercoat Gloss Black		18-7-16
150	QC	1 pcs	7/12/18	7/12/18	0.00	0.00	QC3		
180	Packaging	1 pcs	7/12/18	7/12/18	0.00	0.00	Packaging3-2		
190	QC21-SA	1 Ea	7/12/18	7/12/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank to 39.750" Batch:

Descriptions: 110 - 1-Machine per folio FB006 2- deburr rough edges

145 - MASK AS PER DWG

DAS
21
9-89

JUL 17 2018

M138839 JARI: 2+15 O.U.T: 300" FINISH: 315

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	3.3125 ft (3.3125 ea)	90-Start up Operation	5590370 5091623

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	3	9	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ De _____	DISPOSITION	 Container No: S091625 Part: D4275-1 Job No: 180387 Serial No/Batch: S091625 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/31/18 DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartero.com www.dartaerospace.com															
		AGAINST DEPARTMENT/PROCESS		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Water Jet</td> <td style="width:33%;">Engineering</td> <td style="width:33%;"></td> </tr> <tr> <td>Prod. Eng. Coord.</td> <td>Quality</td> <td></td> </tr> <tr> <td>Rec/Store/Packaging</td> <td>Other</td> <td></td> </tr> <tr> <td>Supplier</td> <td></td> <td></td> </tr> </table>		Water Jet	Engineering		Prod. Eng. Coord.	Quality		Rec/Store/Packaging	Other		Supplier		
Water Jet	Engineering																
Prod. Eng. Coord.	Quality																
Rec/Store/Packaging	Other																
Supplier																	
				MRB (QSI042) Approval													
				Completed By													
				Lead hand / Supervisor Approval Verification													
				QC / QA Coordinator Approval													

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-formation	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	

DART AEROSPACE LTD		Work Order:	180387
Description: Fwd Beam		Part Number:	D4275-1
Inspection Dwg: D4275 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.748	V		Ver	
26.700	+/-0.010	26.700	V		TAPE	
Ø0.381	+0.000/-0.001	Ø.380	V		G.P.	
8.280	+/-0.010	8.280	V		H.G.	
1.44	+/-0.030	1.44	V		Ver	
0.95	+/-0.030	.95	V		Ver	
3.50	+/-0.030	3.50	V		Ver	
13.28	+/-0.030	13.28	V		TAPE	
13.50	+/-0.030	13.50	V		TAPE	
9.25	+/-0.030	9.25	V		TAPE	
5.00	+/-0.030	5.00	V		Ver	
0.75	+/-0.030	0.75	V		Ver	
2.75	+/-0.030	2.75	V		Ver	
3.00	+/-0.030	3.00	V		Ver	
1.250	+/-0.010	1.250	V		Ver	
4.50	+/-0.030	4.5	V		Ver	
0.734	+/-0.010	.735	V		Mic	
0.108	+/-0.010	.108	V		D.G.	
39.48	+/-0.030	39.48	V		TAPE	
0.95	+/-0.030	0.945	V		Ver	
0.60	+/-0.030	0.60	V		Ver	
1.750	+/-0.010	1.750	V		Ver	
2.700	+/-0.010	2.700	V		Ver	
1.10	+/-0.030	1.10	V		Ver	
1.25	+/-0.030	1.25	V		Ver	
0.900	+/-0.010	0.900	V		H.G.	
0.75	+/-0.030	0.75	V		Ver	
0.250	+/-0.010	0.250	V		Ver	
3.000	+/-0.010	3.000	V		Ver	
1.500	+/-0.010	1.500	V		Ver	
Ø0.191	+0.005/-0.001	.193	V		Ver	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								OTHER : _____																																							

DQA: _____ Date: _____



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OTHER : _____					